

OLD style
OLD STYLE! Sept. 9

Dart Aerospace Ltd.

Date: Tuesday, 15/08/2006 3:04:58 PM
User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STA 84 BRACKET
Job Number	: 28200	Part Number	: D28031
Estimate Number	: 11034	Drawing Number	: D2803 REV B
P.O. Number	: N/A	Project Number	: N/A
This Issue	: 15/08/2006 S.O. No. : N/A	Drawing Revision	: B
Prsht Rev.	: NC	Material	: N/A
First Issue	: N/A Type : MACHINED PARTS	Due Date	: 08/09/2006
Previous Run	: 27684	Qty:	8 Um: Each
Written By	: _____		
Checked & Approved By	: _____		
Comment	: Est. A00.11.06 New Issue EC Est Rev:B Blanks Now Cut on Waterjet 06-06-14 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B0500X10000	6061-T6 Bar .50" x 10.0"
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Comment: Qty.: 2.0125 f(s)/Unit Total: 16.1003 f(s)

6061-T6 Bar .50" x 10.0"

Material: 6061-T6 bar 10.00" x 0.50"

Batch: M101262

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per template DT8533

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

SAD 06.08.16

8

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per folio FA102

JL/SA 06.08.23

8

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

JL/SA 06.08.23

8

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

ml 06/08/24

8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: DP Date: 06/08/30
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 15/08/2006 3:04:59 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STA 84 BRACKET

Job Number: 28200

Part Number: D28031

Job Number:



Seq. #: Machine Or Operation: Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1.
Tumble & Deburr

7/12/06 06/03/24 8

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06-08-29

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1

DL 06/09/29 (8)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: *ST/56*

06/09/29 (8)
06/08/29 (8)

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL
Inspection Level 21

06/08/30 (8)

Job Completion



C 06/08/29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

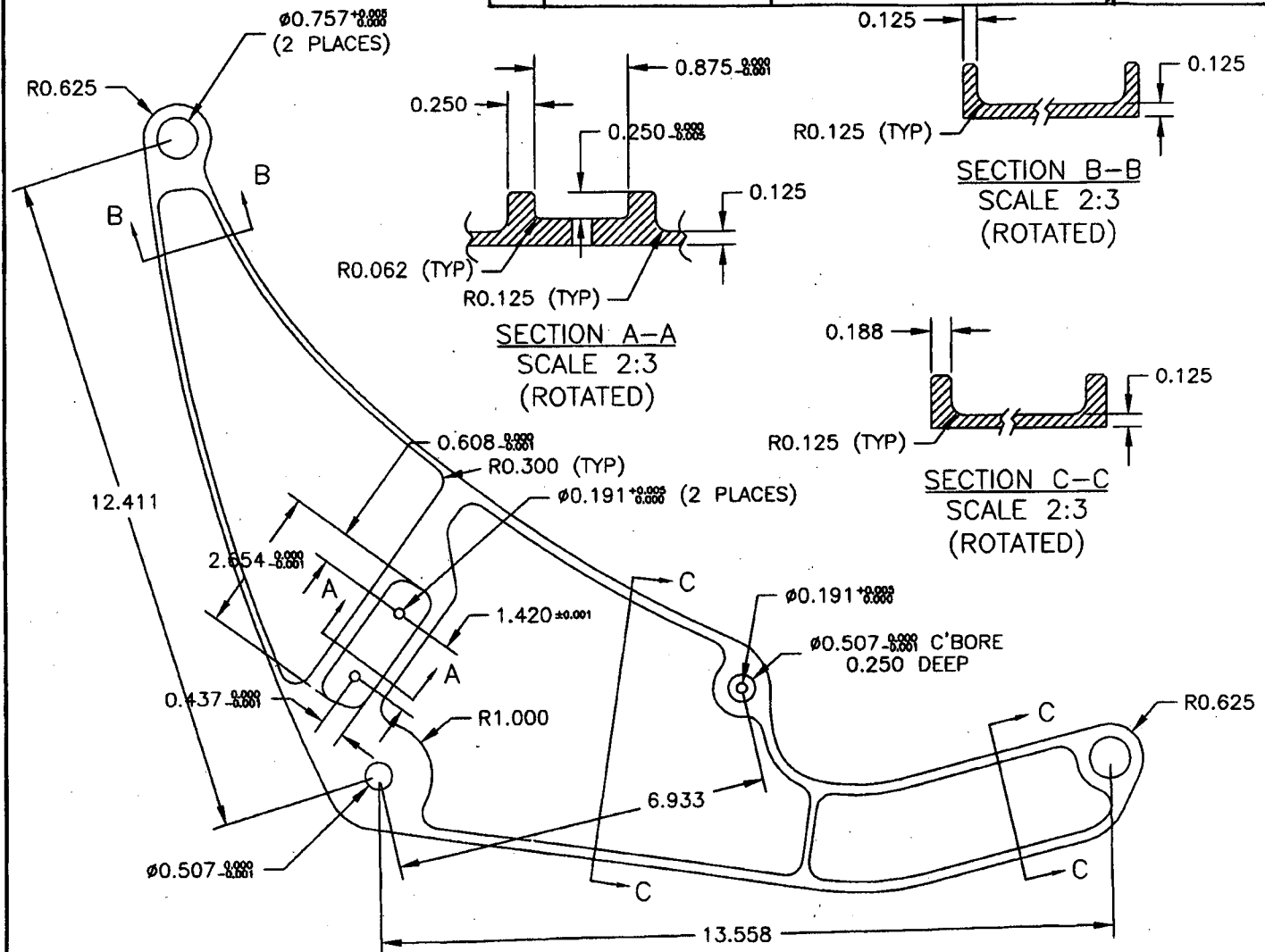
SUPERCEDED BY

05.02.18

DART



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D2803	REV. A SHEET 1 OF 2
DATE 00.11.07		TITLE STA 84 BRACKET	SCALE 1:3
A	00.11.07	NEW ISSUE	
A1	01.03.14	ADD D2803-043/-044	



D2803-1 (SHOWN)
D2803-2 (OPPOSITE)

RELEASED
00-11-13

MACHINE PER DRAWING FILE "D2803-A1.DWG"
MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

REFERENCE ONLY

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

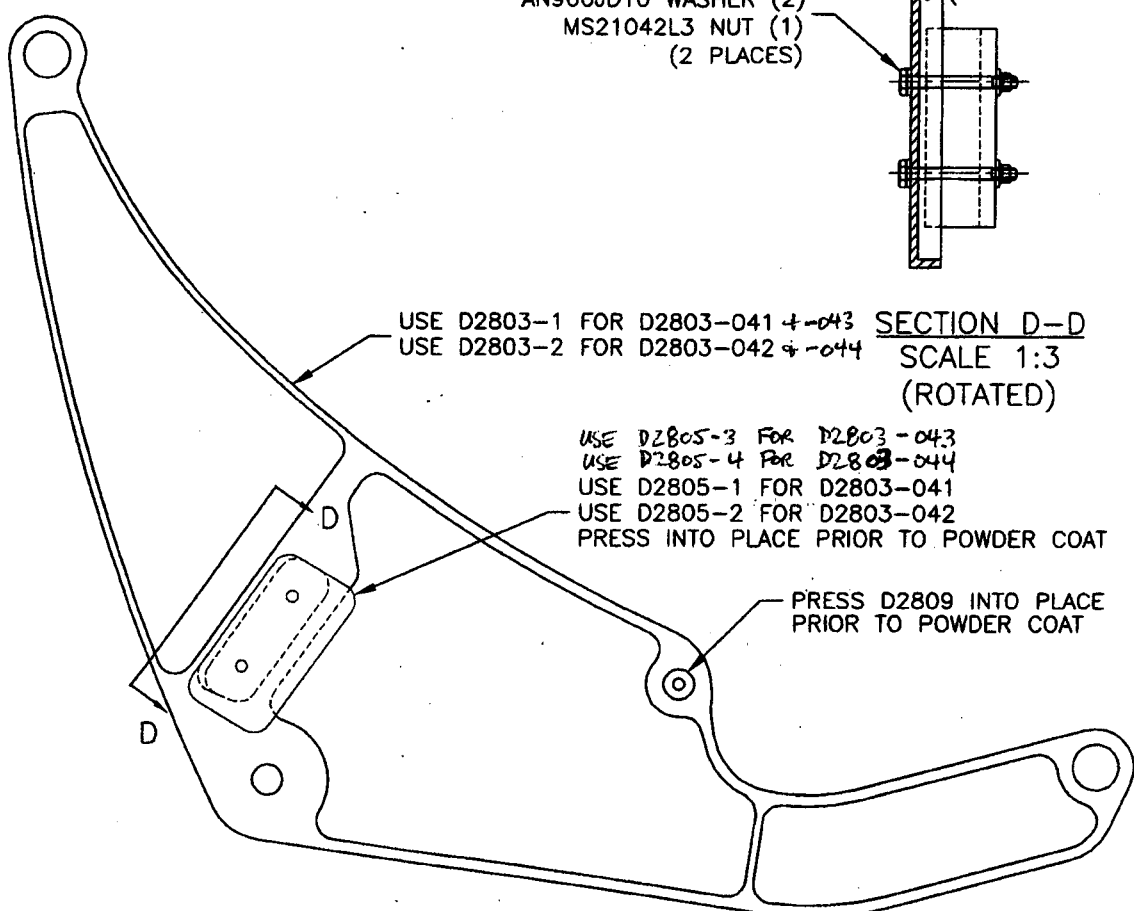
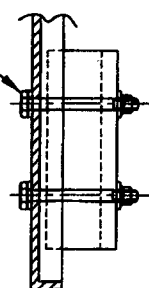
NOTE: Date & initial all entries



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2803	REV. A SHEET 2 OF 2
DATE 00.11.07		TITLE STA 84 BRACKET	SCALE 1:3

RELEASED
00.11.12

- AN3-16A BOLT (1)
- AN960JD10 WASHER (2)
- MS21042L3 NUT (1)
- (2 PLACES)



USE D2803-1 FOR D2803-041 + -043
USE D2803-2 FOR D2803-042 + -044
SECTION D-D
SCALE 1:3
(ROTATED)

- USE D2805-3 FOR D2803-043
- USE D2805-4 FOR D2803-044
- USE D2805-1 FOR D2803-041
- USE D2805-2 FOR D2803-042
- PRESS INTO PLACE PRIOR TO POWDER COAT

PRESS D2809 INTO PLACE
PRIOR TO POWDER COAT

D2803-041 ASSEMBLY (SHOWN) → D2803-043 SIMILAR
D2803-042 ASSEMBLY (OPPOSITE) → D2803-044 SIMILAR

FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY
SANDTEX (4.3.5.6) OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX
(4.3.5.8) PER DART QSI 005 4.3

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DART AEROSPACE LTD		Work Order:
Description:		Part Number:
Inspection Dwg:	Rev:	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

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First Article

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Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø 507	+0.000 -0.001	Ø 507	/			
Ø 757	+0.005 -0.006	Ø 756	/			
Ø 191	+0.005 -0.001	Ø 194	/			
.250 deep	+0.010	.245	/			
R.625	+0.010	R.626	/			
1.420	+0.001	1.4195	/			
250	+0.010	.250	/			
.875	+0.000 -0.001	.875	/			
.250	+0.000 -0.005	.247	/			
.125	+0.010	.125	/			
.125	+0.010	.130	/			
R.125	+0.010	R.125	/			
.188	+0.010	.189	/			
.125	+0.010	.130	/			
R.125	+0.010	R.125	/			

Measured by: SA	Audited by: J.F.	Prototype Approval:
Date: 06/08/23	Date: 06/08/23	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	